



APKT.PM 1003 Z5



APPLICATION

- Suitable for steel and super alloy, also without coolant
- It is an excellent grade for unstable cutting conditions with low up to medium cutting speed.

GRADE Z5

This is a PVD TiAlN coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and super alloy

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30 - P50	M30 - M40			S20 - S30	
Sfm ft/min	700 - 420	520 - 350			302 - 130	
Fn Inch/Z	.010 - .017	.010 - .014			.009 - .011	
ap Inch	.020 - .270	.020 - .270			.020 - .270	

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

S (RPM) = $Sfm * 12 / \pi / D$ = rev per minute
F (IPR, inch per revolution) = $S * Fn$ = feed per minute
F (IPM, inch per minute) = $S * Fz * n.flutes$ = feed per minute
Sfm = $S * D * \pi / 12$

MILLING CARBIDE INSERT